

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018944**Date Inspected:** 29-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER & OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

OPEN YARD (NEAR TO OBG TRIAL ASSEMBLY YARD)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 007544

Visual Inspection Testing (VT)

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as TOWER Component. The identified component designations reviewed are as follows:

TOWER RAILING

SSD1-RA4-60-1

SSD1-RA4-1-2

SSD1-RA4-2-19, 06, 01

SSD1-RA4-30-07

SSD1-RA4-4-07, 10, 36

Magnetic Particle Testing (MT)

This QA inspector performed MT of the area previously tested and accepted by ZPMC Quality Control personnel.

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This QA Inspector generated an MT report for this date. The member is identified as TOWER Component. The weld designation reviewed as follows:

TOWER RAILING

SSD1-RA4-60-1

SSD1-RA4-1-2

SSD1-RA4-2-19, 06, 01

SSD1-RA4-30-07

SSD1-RA4-4-07, 10, 36

BAY#10

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 007548

Magnetic Particle Testing (MT)

This QA inspector performed MT of the area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The member is identified as TOWER Component. The weld designation reviewed as follows:

NORTH TOWER GRATING, LIFT-4 – GREEN TAG#13655

GGSA-70PLAN-116M-3-1~6-N

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 04 located on Tower Façade plate pad eye ND1 – SFSA4 – 710 – 3. Welder is identified as 050038. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112. (See attached photo)

Weld joint # 01 located on Tower Façade plate pad eye ND1 – SFSA4 – 710 – 3. Welder is identified as 050038. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

BAY#11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 007548

Magnetic Particle Testing (MT)

This QA inspector performed MT of the area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The member is identified as TOWER Component. The weld designation reviewed as follows:

WEST TOWER GRATING SUPPORT, LIFT-4 – GREEN TAG#13654

GGSA-69PLAN-116M-3-1~6-W

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 74 located on West Tower Lift-4 skin 'B' Façade WSD1 – FBSA4 – 2A/C. Welder is identified as

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202323. ZPMC Quality Control (QC) Inspector is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2114.

(See attached photo)

Repair welding of weld joint # 06 located on Lift-5 Bracket SD1 – BRSA5 – 1 as per the weld repair report T-WR3776. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Li Bin. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) – Repair - 1.

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 73 located on Bike Path BK005A6 – 003. Welder is identified as 040655. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

Weld joint # 20 located on Bike Path BK005A3 – 003. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

Weld joint # 72 located on Bike Path BK005A8 – 003. Welder is identified as 040655. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

Weld joint # 21 located on Bike Path BK005A3 – 003. Welder is identified as 040655. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

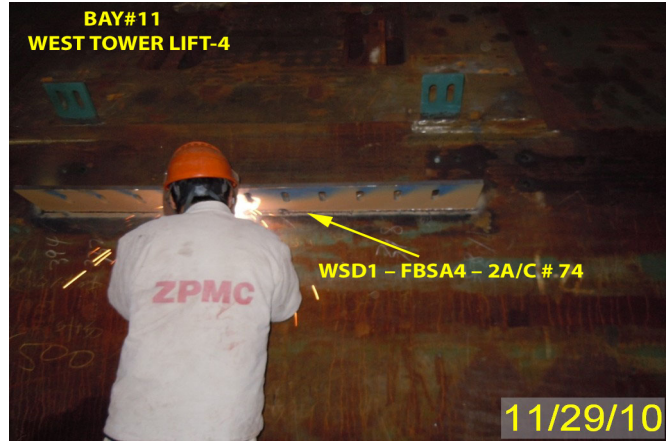
Fluxcored Arc Welding (FCAW):

Weld joint # 20 located on Bike Path BK004ASD1 – 022. Welder is identified as 205649. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho- 15002048250, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer